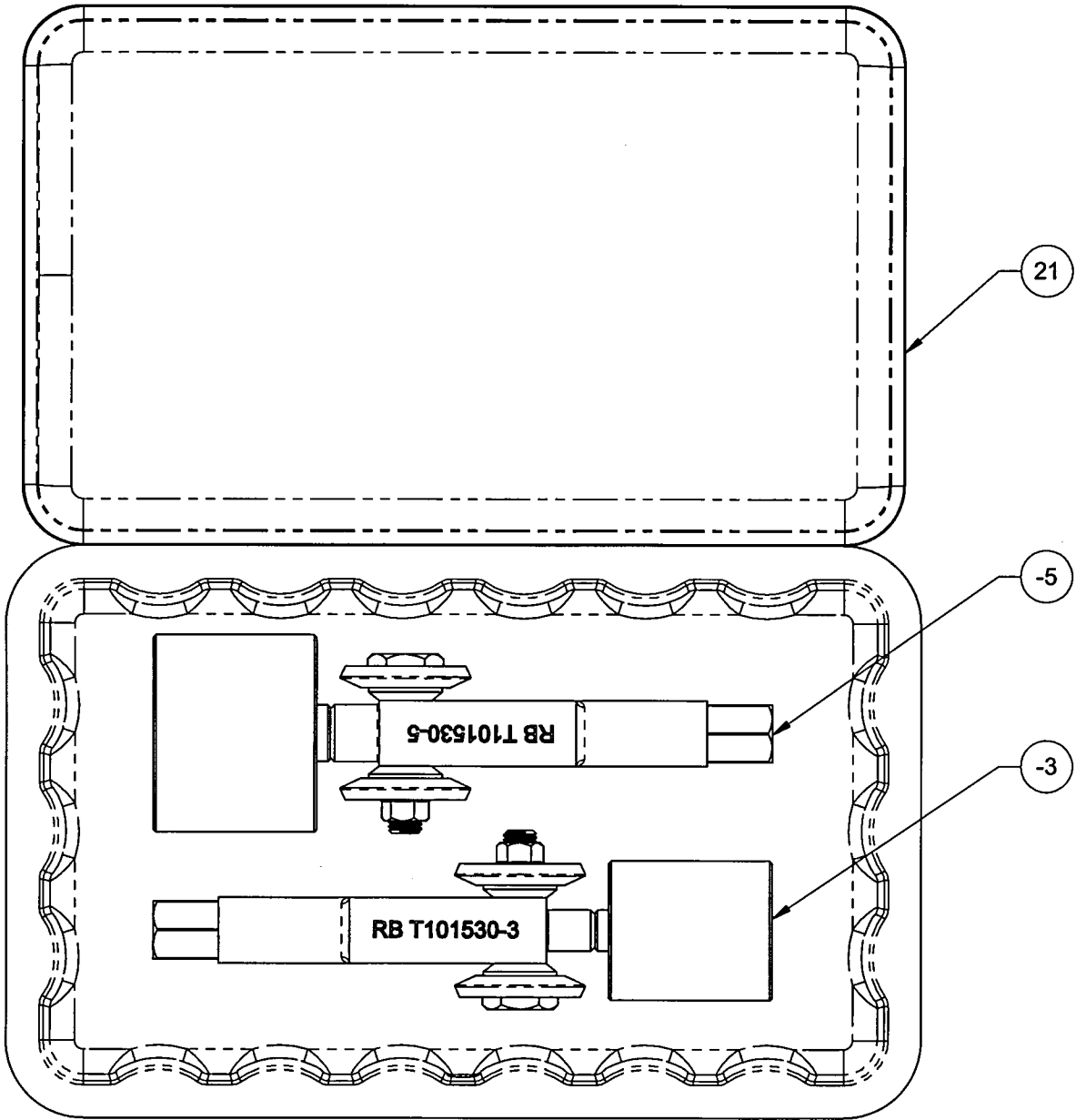


ITEM #	QTY	PART #	PART TITLE
-3	1	RB T101530-3	BEARING ROLL STAKE TOOL
-5	1	RB T101530-5	BEARING ROLL STAKE TOOL
21	1	PELICAN #APP-1040-E	PELICAN CASE

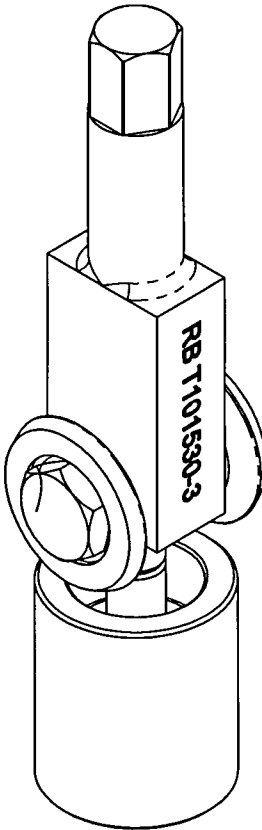
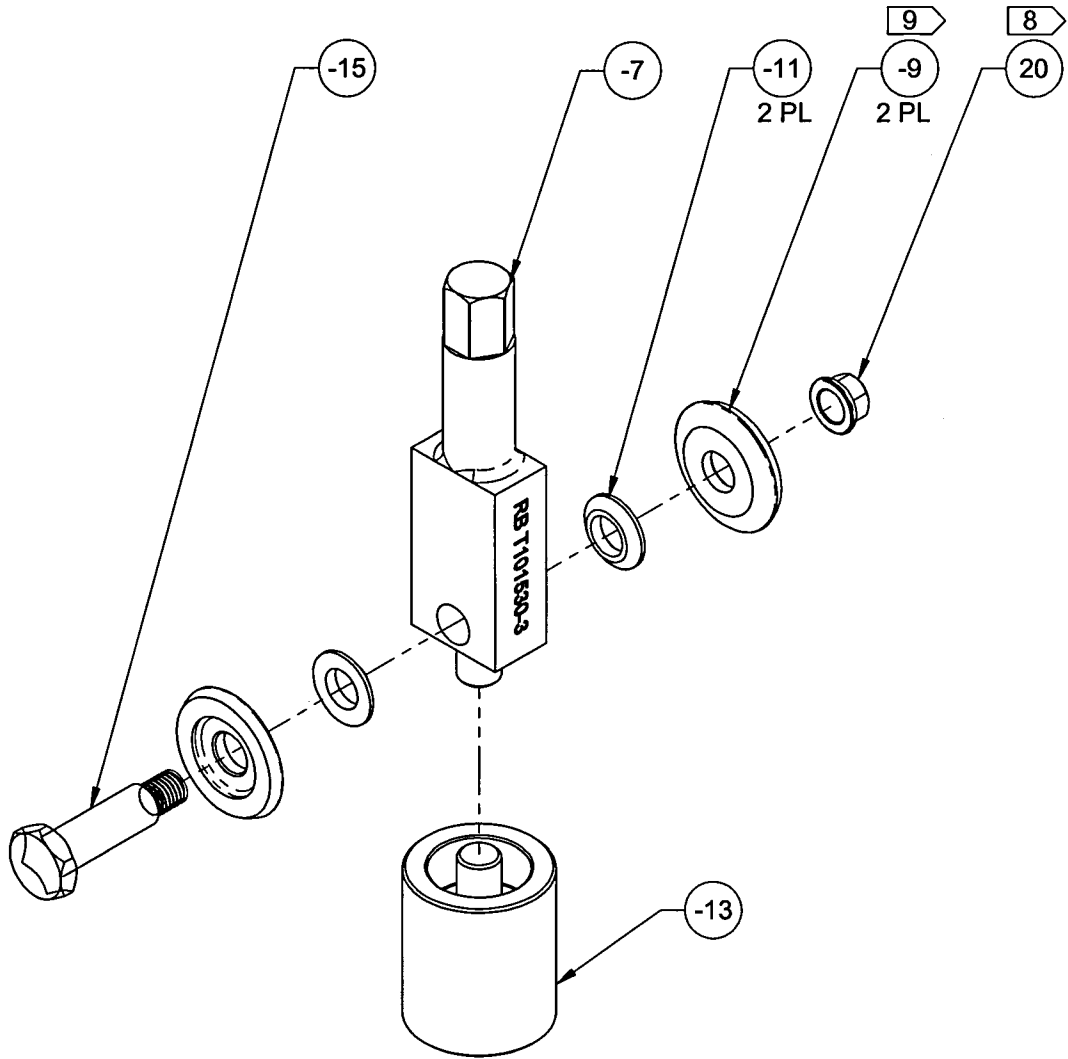
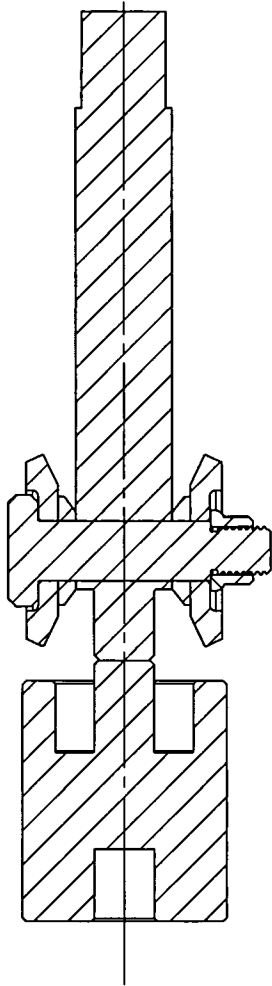


RB T101530 BEARING ROLLER TOOL (-3/-5)

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A

A	NEW ISSUE	18-760	KK
REV.	DESCRIPTION	ECN #	BY
DESIGN	ML	DART AEROSPACE LTD	
DRAWN	KK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	TOOL PART #	REV. A
MFG. APPR.	DP	RB T101530	SHEET 1 OF 10
APPROVED	ML	TITLE	SCALE
DATE 7/4/2018		BEARING ROLLER TOOL (-3/-5)	NTS
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ITEM #	QTY	PART #	PART TITLE
-7	1	RB T101530-7	BODY
-9	2	RB T101530-9	ROLLER
-11	2	RB T101530-11	SPACER
-13	1	RB T101530-13	BASE
-15	1	RB T101530-15	BOLT
20	1	MS21043-4	1/4"-28 LOCKNUT, STAINLESS STEEL

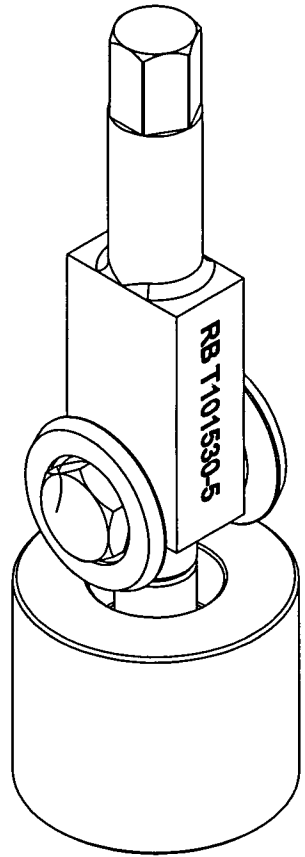
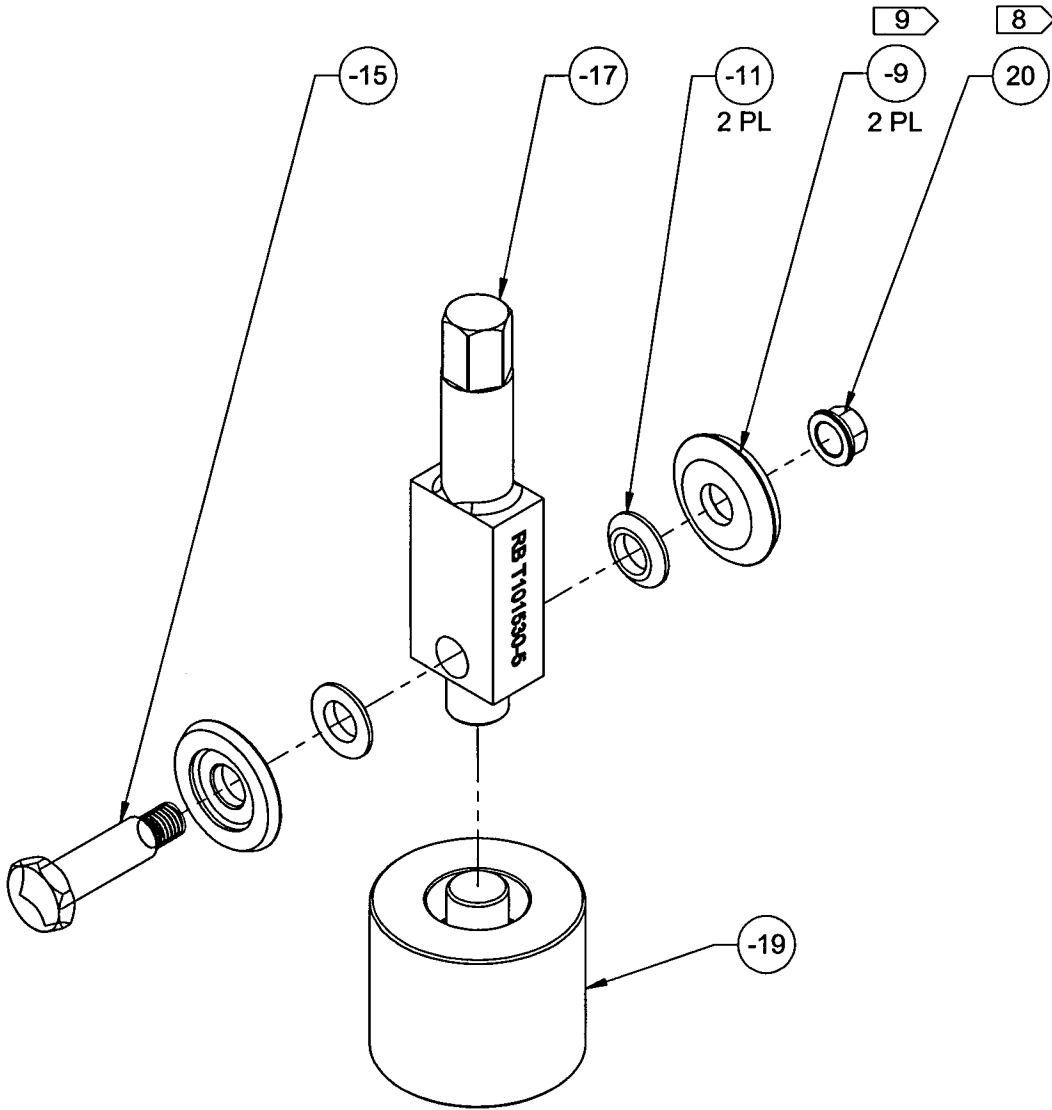
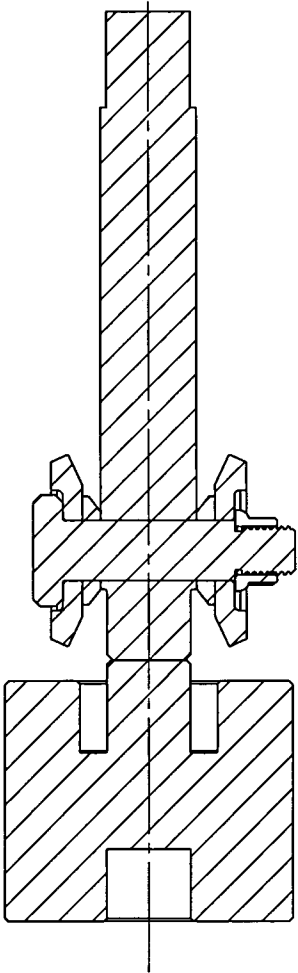


NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) ASSEMBLE AS SHOWN, TORQUE ITEM 20 TO 50-70 IN/LBS.
9) ITEMS -9 MUST ROTATE FREELY.
10) THE TOOL MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG.

RB T101530-3 BEARING ROLL STAKE TOOL 10

DESIGN	KK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KK		
CHECKED	<i>ML</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB T101530	SHEET 2 OF 10
APPROVED	<i>ML</i>	TITLE	SCALE
DATE 7/4/2018		BEARING ROLLER TOOL (-3/-5)	NTS
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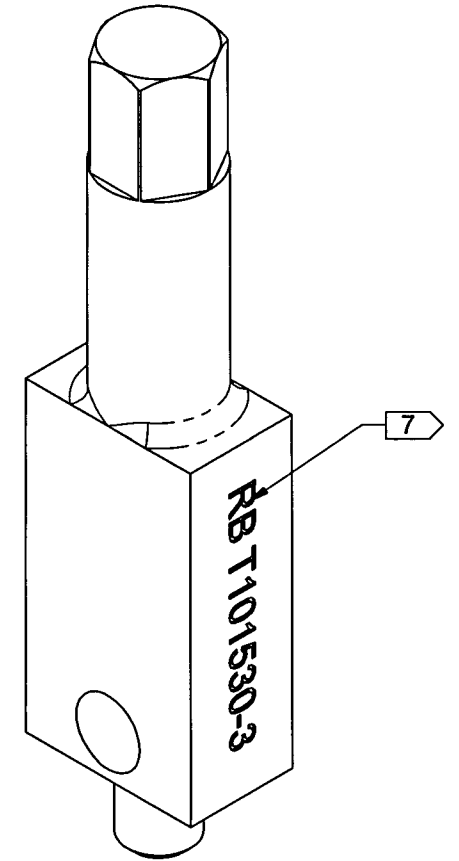
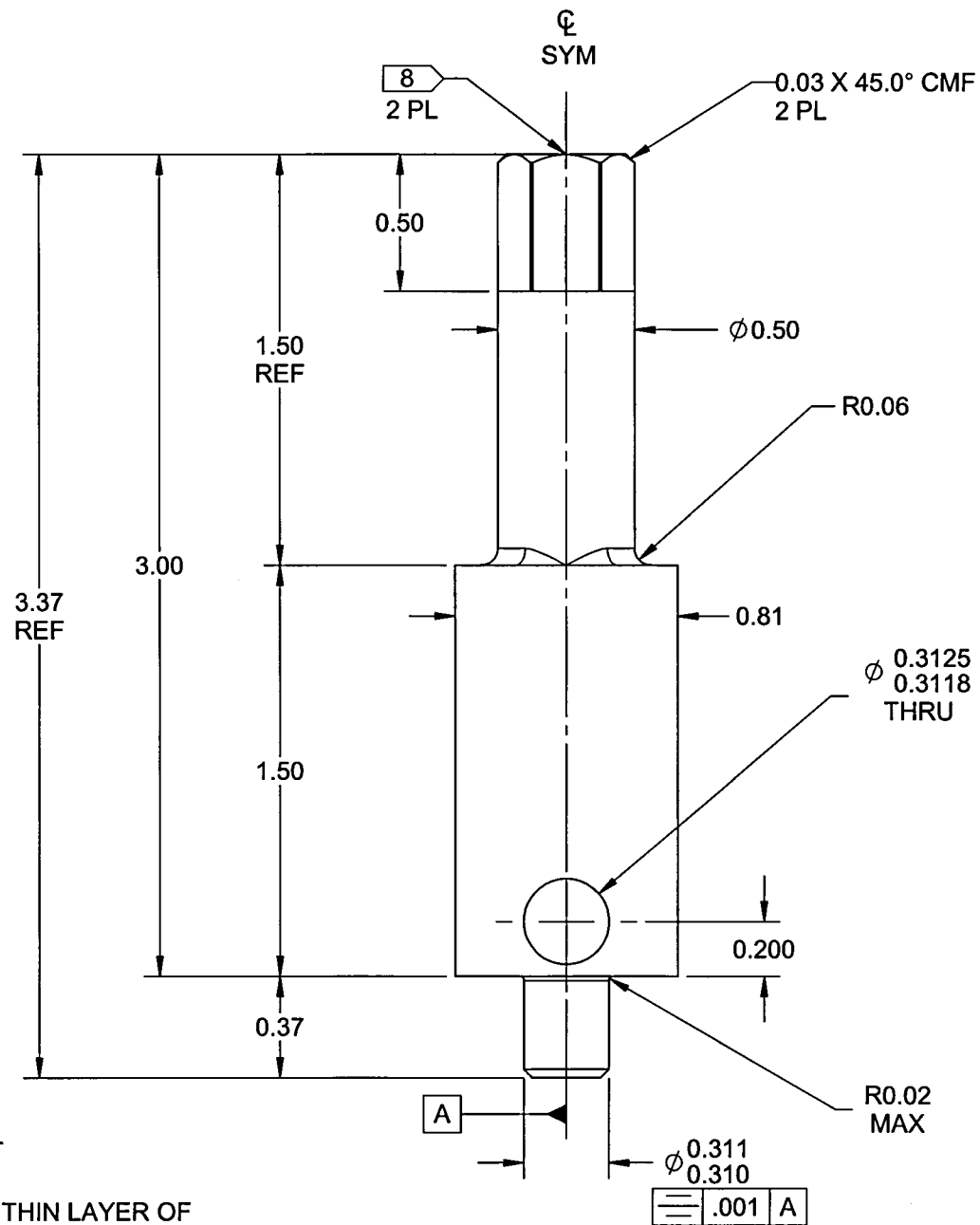
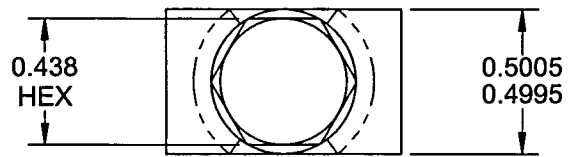
ITEM #	QTY	PART #	PART TITLE
-9	2	RB T101530-9	ROLLER
-11	2	RB T101530-11	SPACER
-15	1	RB T101530-15	BOLT
-17	1	RB T101530-17	BODY
-19	1	RB T101530-19	BASE
20	1	MS21043-4	1/4"-28 LOCKNUT, STAINLESS STEEL



RB T101530-5 BEARING ROLL STAKE TOOL 10

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) ASSEMBLE AS SHOWN, TORQUE FOR ITEM 21 MUST BE 50-70 IN/LBS.
9) ITEMS -9 MUST ROTATE FREELY.
10) THE TOOL MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG.

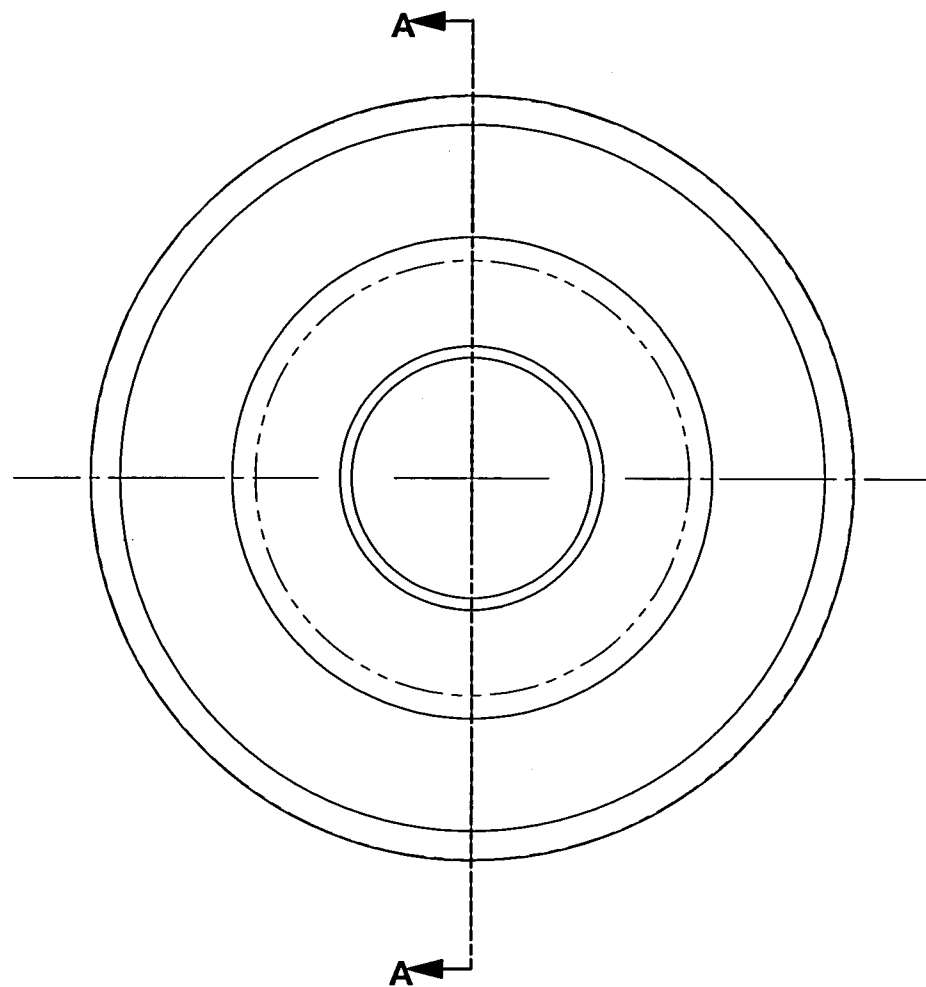
DESIGN	KK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KK		
CHECKED	<i>W. Lee</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB T101530	SHEET 3 OF 10
APPROVED	<i>W. Lee</i>	TITLE	SCALE
DATE 7/4/2018		BEARING ROLLER TOOL (-3/-5)	NTS
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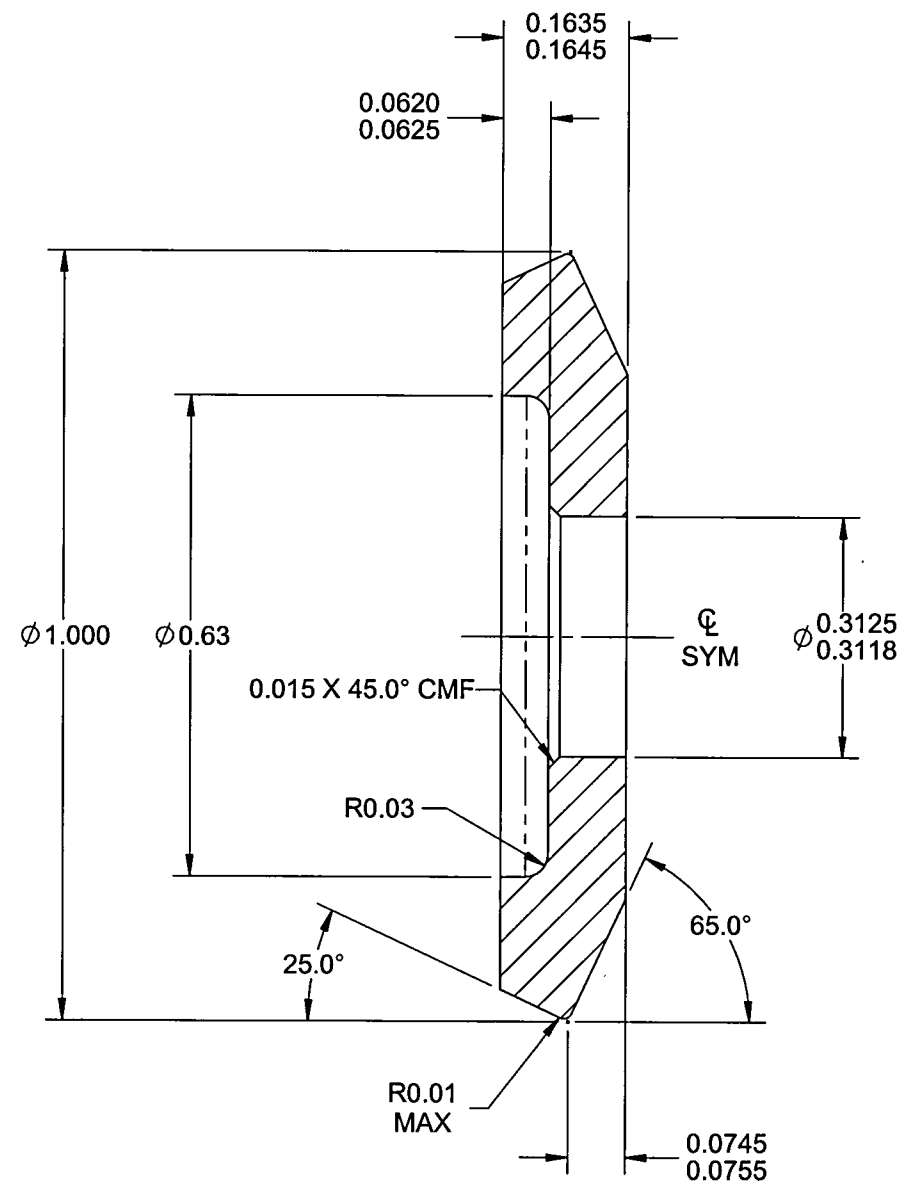
NOTES:
1) MATERIAL: 4140/4142 (28-32 RC) OR 17-4 PH-H900-H1150 STAINLESS STEEL
2) HEAT TREAT: N/A
3) FINISH: 17-4PH: N/A
4140/4142: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF
OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III
OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL OR DOT MARK T/N AS SHOWN.
8) CENTER DRILL IS ACCEPTABLE

RB T101530-7 BODY

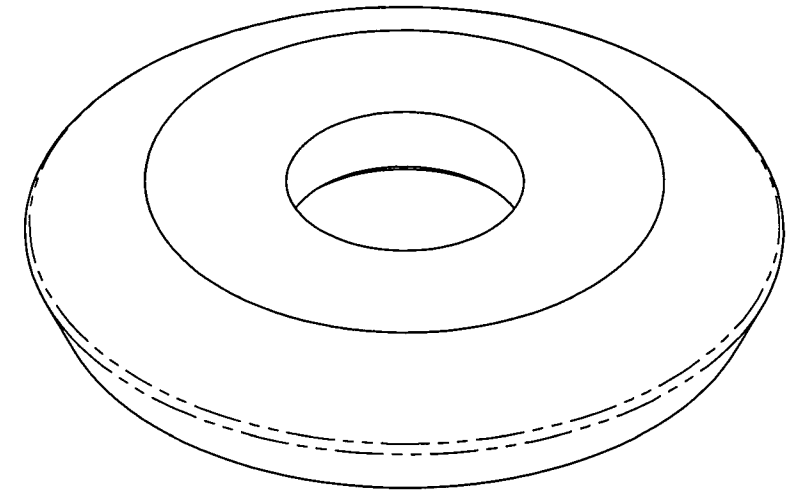
DESIGN	KK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KK		
CHECKED	<i>MDL</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB T101530	SHEET 4 OF 10
APPROVED	<i>MDL</i>	TITLE	SCALE
DATE 7/4/2018		BEARING ROLLER TOOL (-3/-5)	NTS
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RB T101530-9 ROLLER

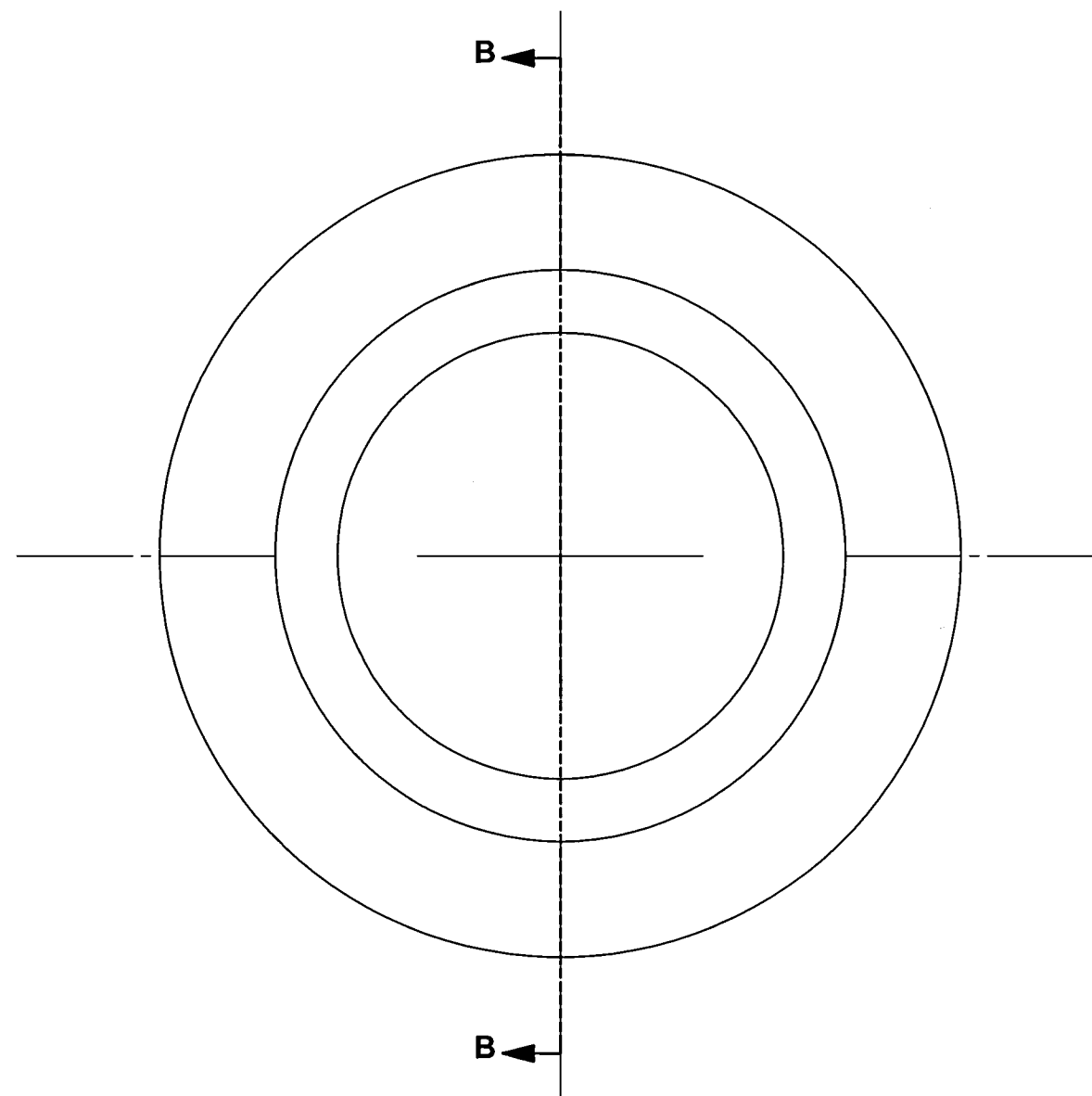


SECTION A-A

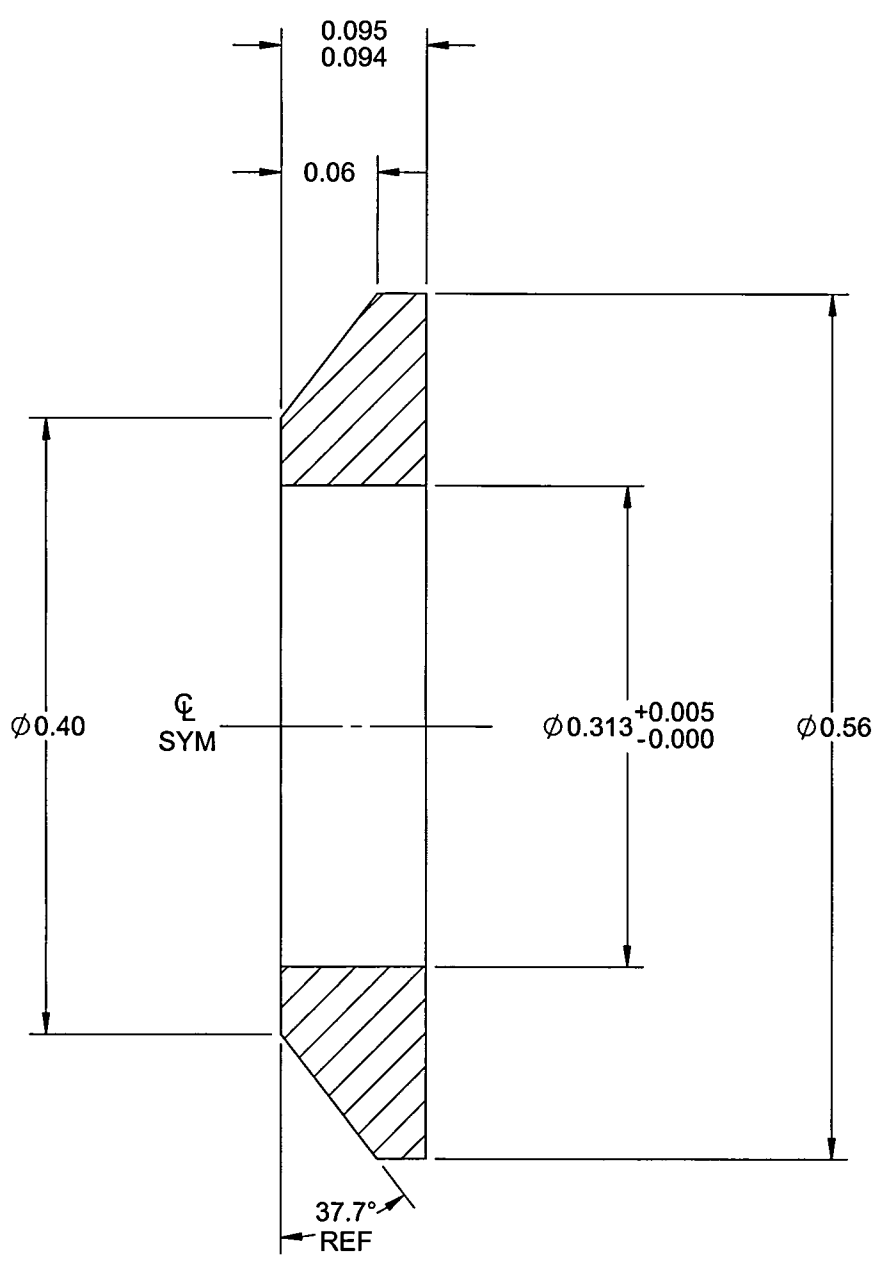


- NOTES:
- 1) MATERIAL: O1
 - 2) HEAT TREAT: 50-60 RC
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

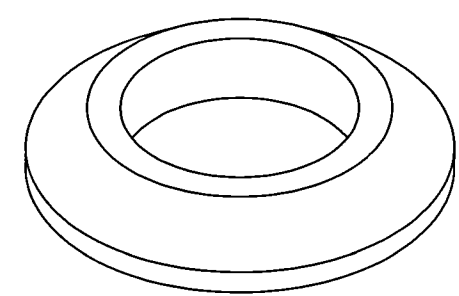
DESIGN	KK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KK		
CHECKED	<i>MP</i>	TOOL PART # RB T101530	REV. A
MFG. APPR.	DP		SHEET 5 OF 10
APPROVED	<i>MP</i>	TITLE BEARING ROLLER TOOL (-3/-5)	SCALE NTS
DATE 7/4/2018		COPYRIGHT © 2018 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



RB T101530-11 SPACER

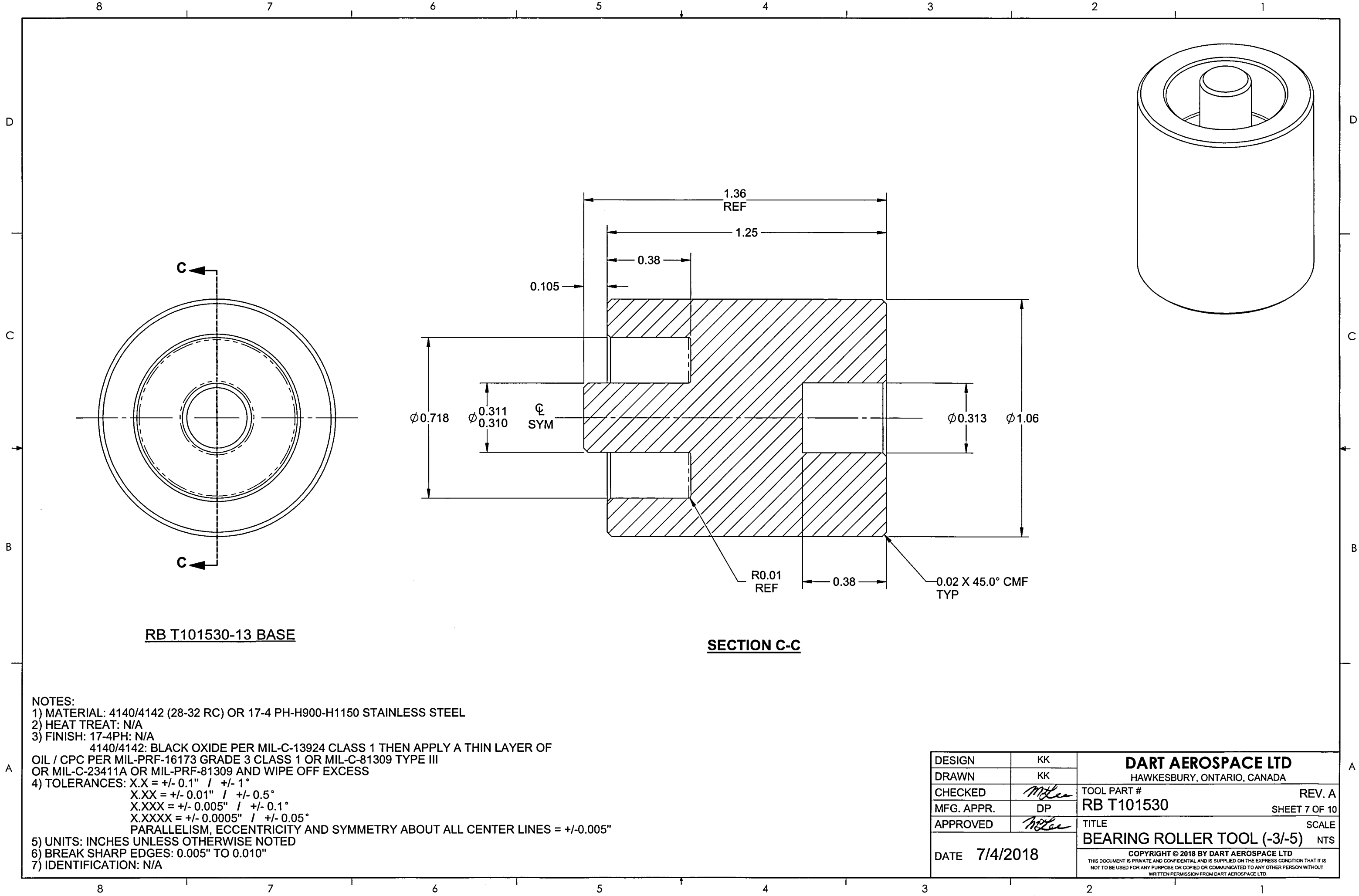


SECTION B-B



- NOTES:
- 1) MATERIAL: BRONZE C63000
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

DESIGN	KK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KK		
CHECKED	<i>ML</i>	TOOL PART # RB T101530	REV. A
MFG. APPR.	DP		SHEET 6 OF 10
APPROVED	<i>ML</i>	TITLE	SCALE
DATE 7/4/2018		BEARING ROLLER TOOL (-3/-5)	NTS
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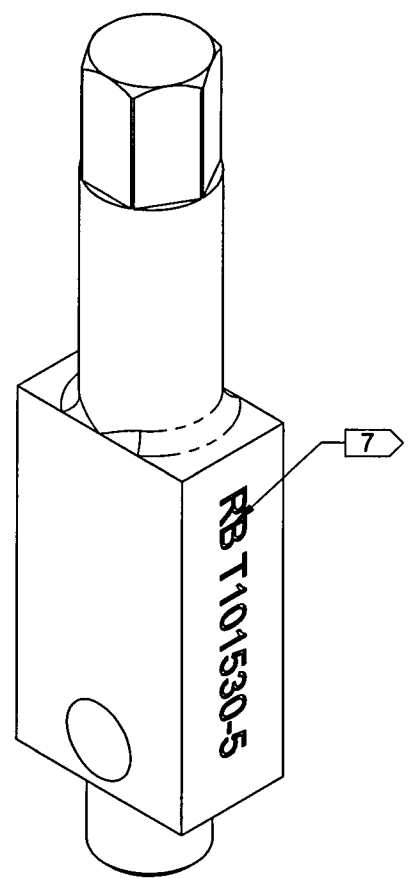
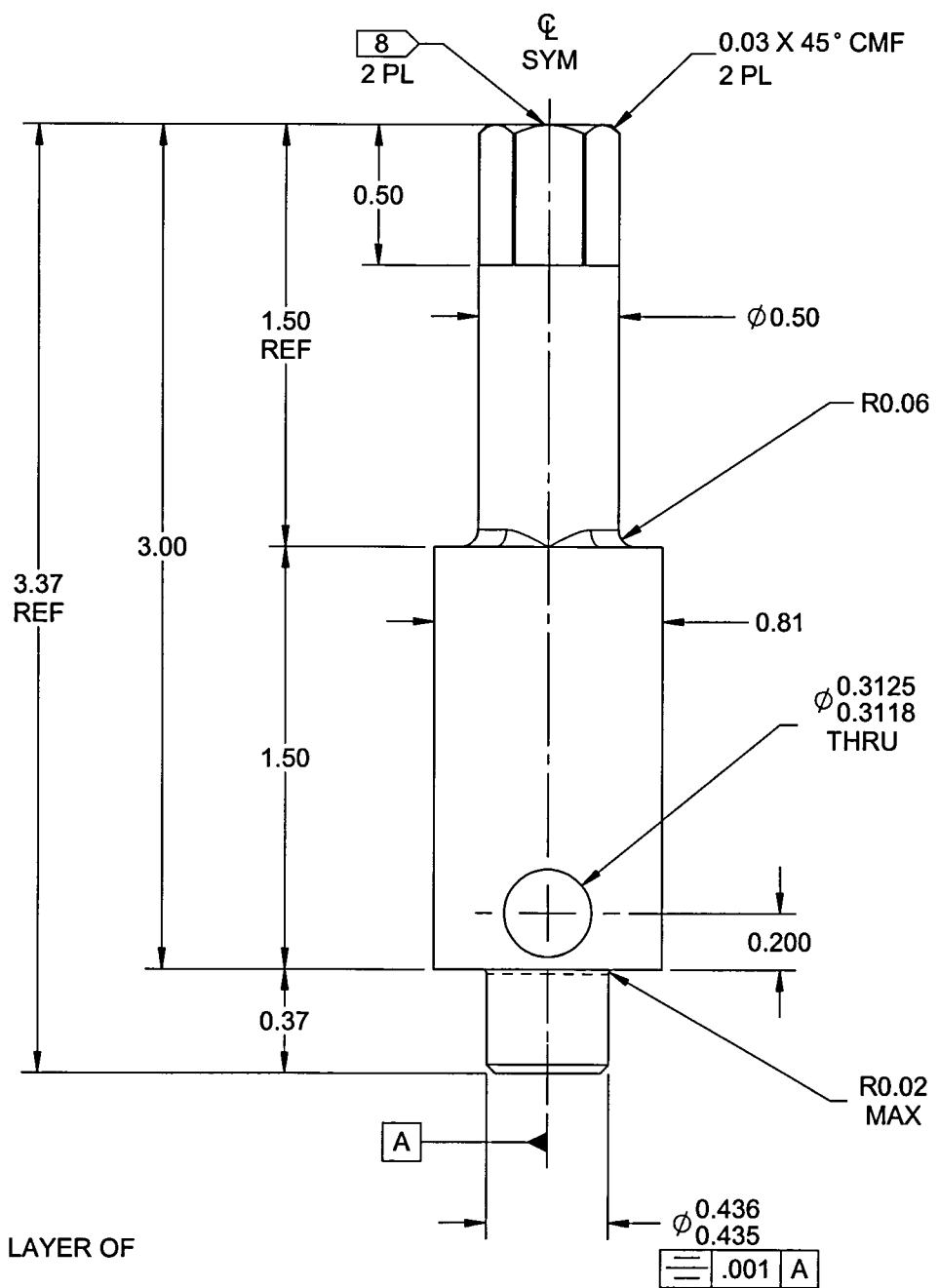
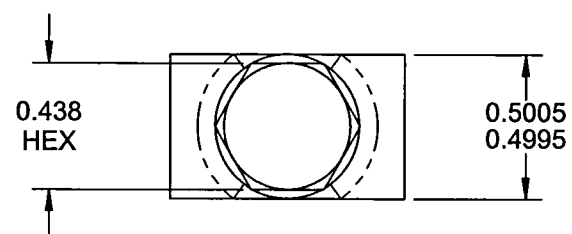


RB T101530-13 BASE

SECTION C-C

NOTES:
1) MATERIAL: 4140/4142 (28-32 RC) OR 17-4 PH-H900-H1150 STAINLESS STEEL
2) HEAT TREAT: N/A
3) FINISH: 17-4PH: N/A
4140/4142: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF
OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III
OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

DESIGN	KK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KK		
CHECKED	<i>M. Lee</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB T101530	SHEET 7 OF 10
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE 7/4/2018		BEARING ROLLER TOOL (-3/-5)	NTS
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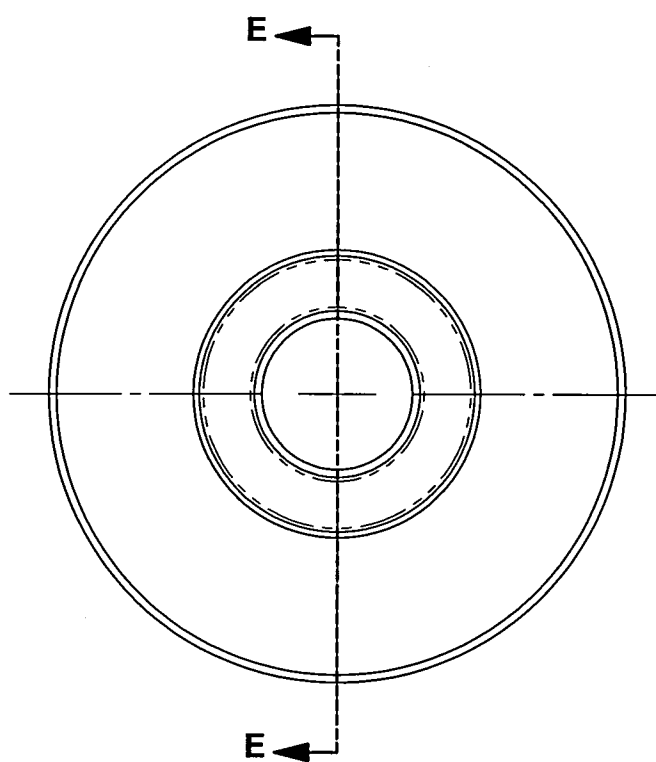


RB T101530-17 BODY

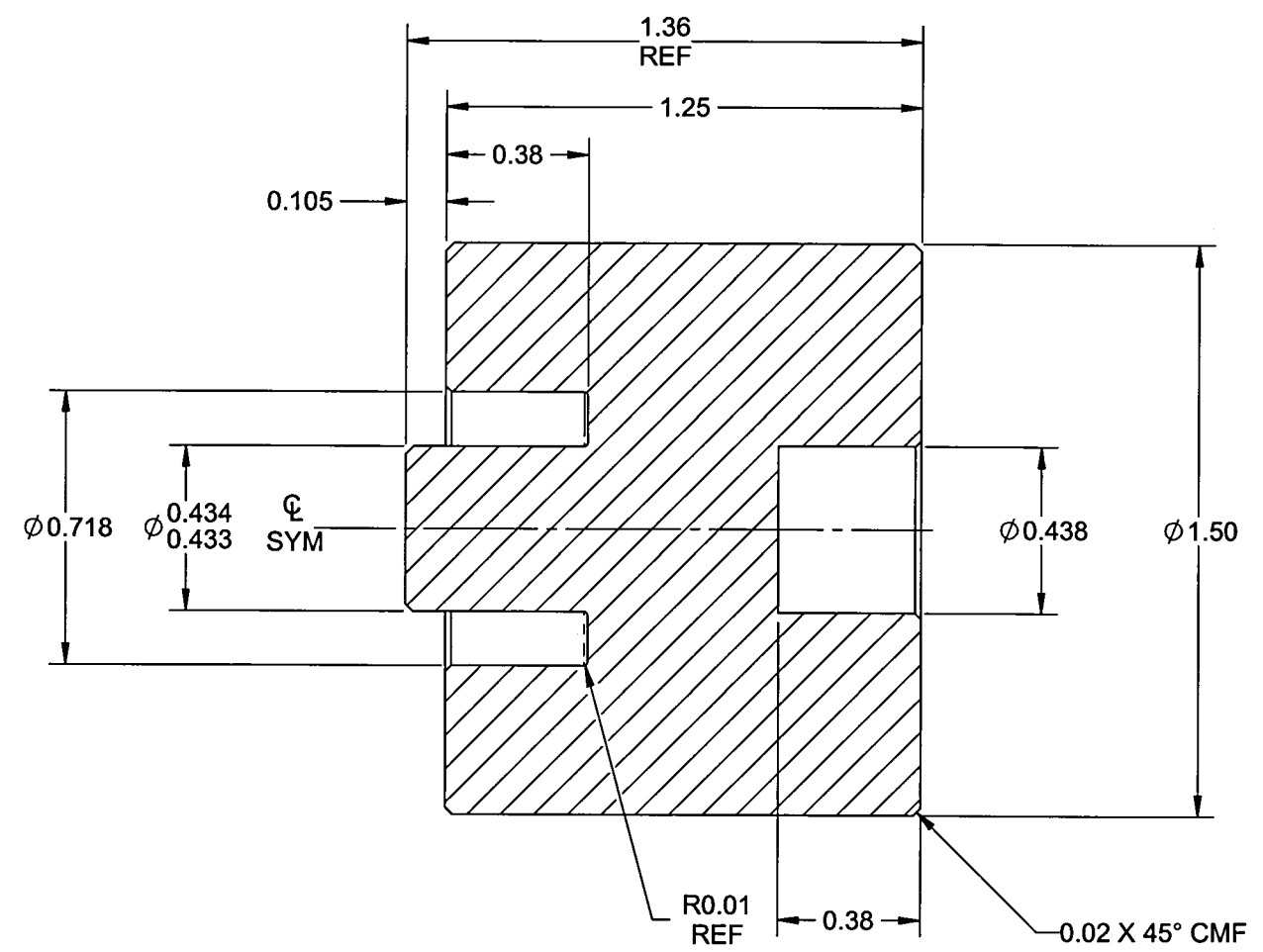
NOTES:
1) MATERIAL: 4140/4142 (28-32 RC) OR 17-4 PH-H900-H1150 STAINLESS STEEL
2) HEAT TREAT: N/A
3) FINISH: 17-4PH: N/A
4140/4142: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL OR DOT MARK T/N AS SHOWN.
8) CENTER DRILL IS ACCEPTABLE

DESIGN	KK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KK		
CHECKED	<i>ML</i>	TOOL PART # RB T101530	REV. A
MFG. APPR.	DP		SHEET 9 OF 10
APPROVED	<i>ML</i>	TITLE BEARING ROLLER TOOL (-3/-5)	SCALE NTS
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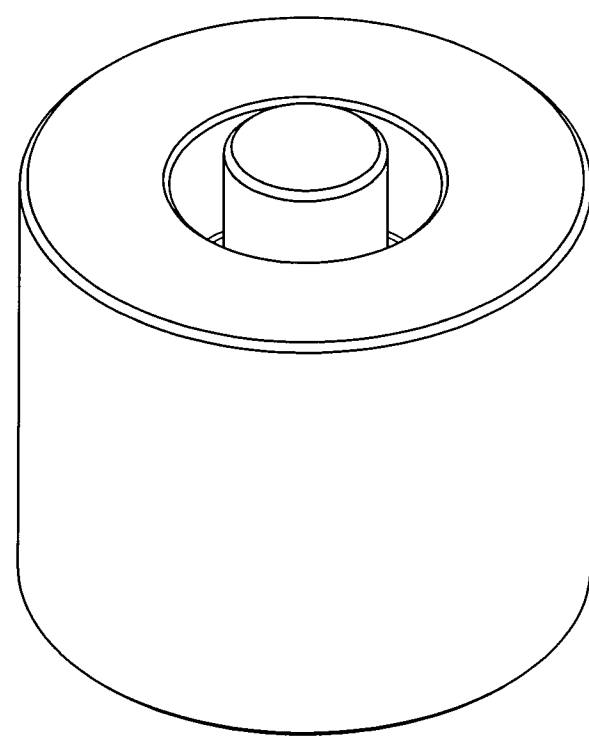
D
C
B
A



RB T101530-19 BASE



SECTION E-E



D
C
B
A

- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC) OR 17-4 PH-H900-H1150 STAINLESS STEEL
 - 2) HEAT TREAT: N/A
 - 3) FINISH: 17-4PH: N/A
4140/4142: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

DESIGN	KK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KK		
CHECKED	<i>ML</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB T101530	SHEET 10 OF 10
APPROVED	<i>ML</i>	TITLE	SCALE
DATE 7/4/2018		BEARING ROLLER TOOL (-3/-5)	NTS
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